

Shp Oct. 20

Work Order ID 59465

June 4, 2010 11:51:35 AM

Page 1

Item ID: D4122-1

Revision ID:

Item Name: Floor Protector, Fwd

Start Date: 6/10/10 Start Qty: 3.00

Required Date: 6/14/10 Req'd Qty: 3.00

Reference:

PRELIMINARY ISSUE

Accept

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4122

A B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg
Dwg Rev: B
Prog Rev: B
2-Deburr if necessary

B 10-10-20

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-10-20

120

0.00



QC8- Inspect parts - second check

QC

Memo per Rev. B
not stamped
released,
10/10/20

0.00

Quality Control

3

10/10/20
To Rev B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59465

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Item ID: D4122-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Fwd

Start Date: 6/10/10

Start Qty: 3.00



Cust Item ID:

Required Date: 6/14/10

Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr if necessary.

Ep 10/10/20 (3)

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

3

150

0.00



Identify as per dwg & Stock Location:

P/P
G 3081

0.00

Packaging

Memo

Packaging

6/10/10 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 4, 2010 11:51:35 AM

Page 1

Work Order ID: 59465

Parent Item: D4122-1

Parent Item Name: Floor Protector, Fwd

Comments: IPP Rev:A 10.06.04 new issue DD verf:JLM

Start Date: 6/10/10

Required Date: 6/14/10

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	1,762.106	27.143	85.71474			



GE PLASTICS LEXAN SHEET



1810-10-20

Location

Loc Qty

Loc Code

MAT

1762.1068

111710

64

112585

165.783

114032

1532.3238

115261

115261

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 59465
Description: FLOOR PROTECTOR FWD		Part Number: D4122-1
Inspection Dwg: D4122-1 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

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First Article

☐

Prototype

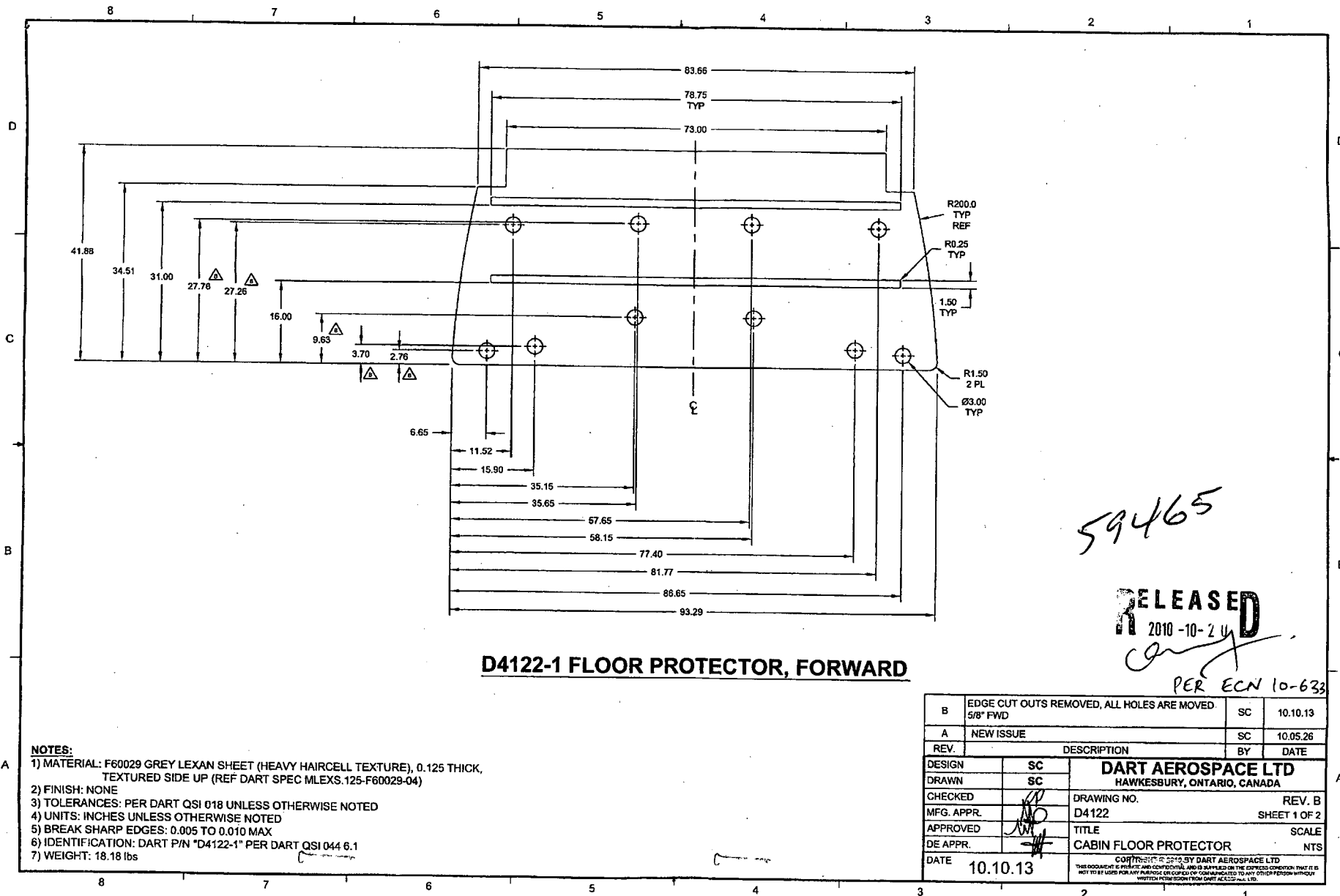
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.00	+0.02 - .001	3.008	x		V RB02	
1.50	± .030	1.480	x		V	
2.76	± .030	2.76	x		T RB01	
3.70	± .030	3.70	x		T	
9.63	± .030	9.63	x		T	
16.00	± .030	16.00	x		T	
27.26	± .030	27.26	x		T	
27.76	± .030	27.76	x		T	
31.00	± .030	31.00	x		T	
34.51	± .030	34.50	x		T	
41.88	± .030	41.875 41.880	x		T	
73.00	± .030	73.00	x		T	
78.75	± .030	78.75	x		T	
83.66	± .030	83.66	x		T	
6.65	± .030	6.65	x		T	
11.52	± .030	11.52	x		T	
15.92	± .030	15.92	x		T	
35.15	± .030	35.15	x		T	
35.65	± .030	35.65	x		T	
57.65	± .030	57.65	x		T	
58.15	± .030	58.15	x		T	
77.40	± .030	77.40	x		T	
81.77	± .030	81.77	x		T	

Measured by: B
Date: 10-10-20

Audited by: [Signature]
Date: 10/10/20

Prototype Approval: N/A
Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



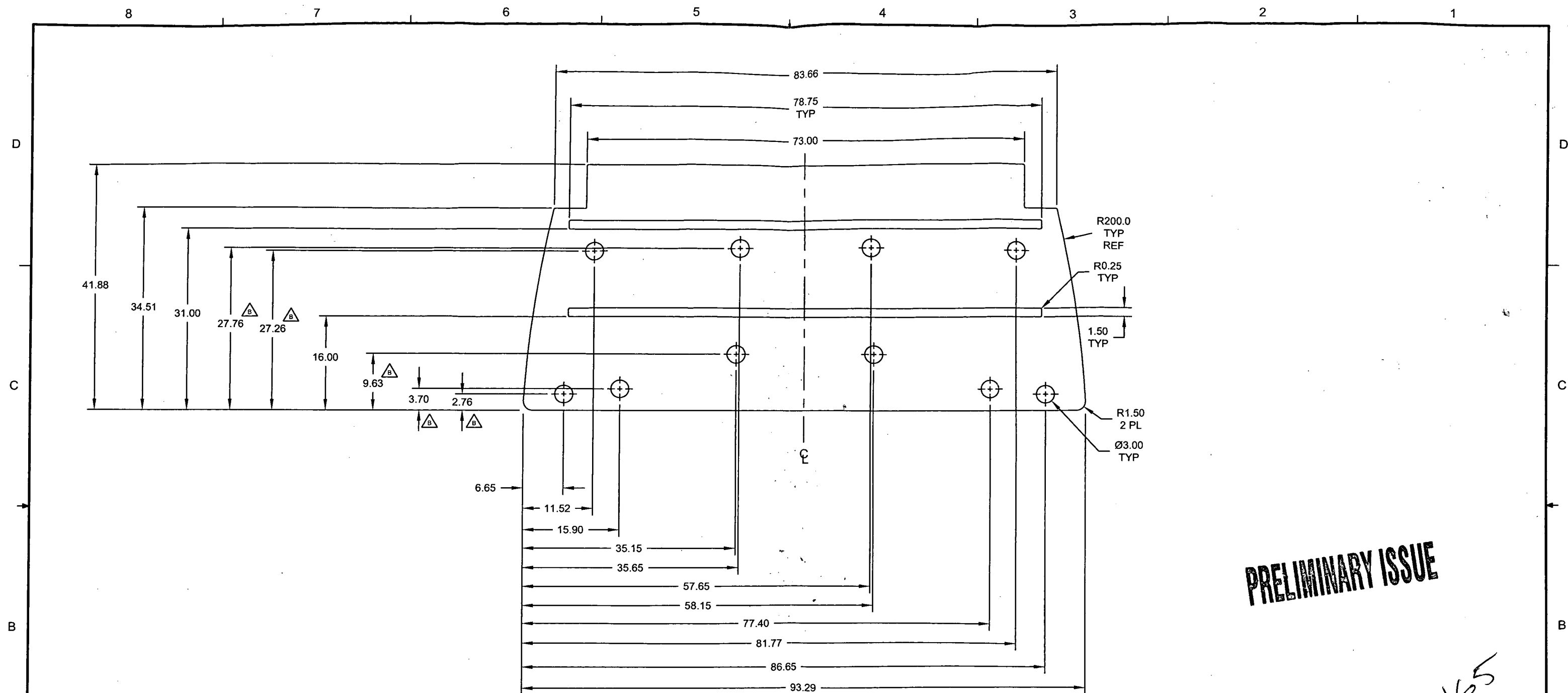
NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D4122-1" PER DART QSI 044 6.1
- 7) WEIGHT: 18.18 lbs

RELEASED
2010-10-24

PER ECN 10-633

B	EDGE CUT OUTS REMOVED, ALL HOLES ARE MOVED. 5/8" FWD	SC	10.10.13
A	NEW ISSUE	SC	10.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4122 SHEET 1 OF 2 TITLE CABIN FLOOR PROTECTOR SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PROPRIETARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	SC		
APPROVED	SC		
DE APPR.	SC		
DATE	10.10.13		



D4122-1 FLOOR PROTECTOR, FORWARD

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DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	JP	D4122	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.		CABIN FLOOR PROTECTOR	NTS
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